



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

6012

C3-K

Job Sheet 184709



Part No: C3-K

Job Qty: 1 ea

Part Name: C-Series Remote Hook 3,000 lbs Lift Capacity - Keeperless



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-K Rev 3 IPP Rev A 18.03.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Small Fab-4		SB
100	Small Fab	1 pcs	11/9/18	11/9/18	0.00	1.00	Small Fab-3		AP SB
110	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC5		21 SB
120	DC	1 pcs	11/9/18	11/9/18	0.00	0.00	DC		21 NOV 29 2018
130	Packaging	1 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-2		DAS SB
140	QC21-SA	1 Ea	11/9/18	11/9/18	0.00	0.00	QC21		21 NOV 29 2018

Part Op 100 - 1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 2. 2- ASSEMBLE AS
Descriptions: PER DWG

120 - Photocopy blue file OM & OOPM-C3 Rev 4

130 - Identify and Stock

GREASE AEROSHELL 20.7 (M138724) SAF-T-ELE (M128063)
LOCTITE 620 (M138933)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	90-Start up Operation	5110495
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	90-Start up Operation	5058763
2505K22 785K75	Heat Shrink Tube	1 pcs (1 ea)	100-Small Fab	5096187
32446	Crimp Terminal	2 Ea (2 ea)	100-Small Fab	5047075
8183K6	Wire Guide/Grip	1 Ea (1 ea)	100-Small Fab	5066770
AN4-16A	Bolt	3 Ea (3 ea)	100-Small Fab	5099494
AN4-17A	Bolt	1 Ea (1 ea)	100-Small Fab	5106972
AN6-15A	Bolt	1 Ea (1 ea)	100-Small Fab	5076004
AN960-10	Washer see part NAS1149F0363P	1 Ea (1 ea)	100-Small Fab	5027738
AN960-10L	Washer, #10 SEE PART NAS1149F0332P	2 Ea (2 ea)	100-Small Fab	5103666
AN960-416	Washer see item NAS1149F0463P	8 Ea (8 ea)	100-Small Fab	5075330 5056461
AN960-616L	5/8" OD, THIN FLAT WASHER see NAS1149F0632P	2 Ea (2 ea)	100-Small Fab	5048297
C2-1-1	Manual Release Knob	1 Ea (1 ea)	100-Small Fab	5100195
C2-10-1	Lock Spring Pin	1 pcs (1 ea)	100-Small Fab	5068051
C2-11-2	Locating Pin	2 Ea (2 ea)	100-Small Fab	5058257
C2-3-1	Latch Shaft Du Bearing	2 pcs (2 ea)	100-Small Fab	5093406
C2-3-10	Latch Shaft	1 Ea (1 ea)	100-Small Fab	5046764
C2-3-11	Actuator	1 pcs (1 ea)	100-Small Fab	5075123
C2-3-2	Latch Roller Pin	1 Ea (1 ea)	100-Small Fab	5029246
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	100-Small Fab	50111638
C2-3-3	Latch Roller	1 Ea (1 ea)	100-Small Fab	5068653

512627

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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C3-12-1	2	53	0
C3-12-2	1	34	0
C3-12-3	1	2	0
C3-12-4	1	33	0
C3-12-5	1	14	0
C3-12-6	2	59	0
C3-13-1	2	42	0
C3-13-4-2	1	0	0
C3-2-1	1	9	0
C3-3-4	2	40	0
C3-3-4-1	4	50	0
C3-3-7	1	15	0
C3-3-9	1	0	0
C3-4-1	2	0	0
C3-4-4KA	1	13	0
C3-7-1	1	26	0
C3-7-2	2	16	0
C3-8-2	1	5	0
C3-8-4	1	23	0
C3-8-5	1	10	0
C3-9-1	1	24	0
C3-9-2	1	44	0
EL-PLUG-M	1	81	0
M27500-16TG2T14	1	83	0
MS21044N4	4	88	0
MS21083-N3	2	72	0
MS21083N6	1	136	0
MS35266-63	1	41	0

Part Specifications

Specifications could not be found.

Plex 10/16/18 10:23 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				



Remote Cargo Hook Test Form

C3

MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOLENOID!

NEW SOLENOID (152951-001)

Work Order 184 709

Customer _____

Serial Number 5/20 102

Date 2018-11-22

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/Fail
1	7,500	Static Hold	Hold for two minutes and reduce load to zero	N/A	Pass
10	1,500	Electircal, 25 volts	No "hang ups" permitted	N/A	Pass
2	3,000	Electircal, 22 volts	Current shall not exceed 12.8 A 9.0	A	Pass
2	2,500	Electircal, 22 volts	Current shall not exceed 12.8 A 9.0	A	Pass
2	2,000	Electircal, 22 volts	Current shall not exceed 12.8 A 8.5	A	Pass
2	1,500	Electircal, 22 volts	Current shall not exceed 12.8 A 8.5	A	Pass
2	500	Electircal, 22 volts	Current shall not exceed 12.8 A 9.5	A	Pass
1	3,000	Electircal, 20 volts	Current shall not exceed 11.6 A 7.5	A	Pass
1	3,000	Electircal, 28 volts	Current shall not exceed 16.2 A 10.0	A	Pass
1	3,000	Manual		N/A	Pass
1	3,000	Impact Test	Impact shackle 10x , shall not release	N/A	Pass
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ω 2.0	Ω	Pass
1	N/A	Electircal Continuity	Across both wires	N/A	Pass

Test Conducted By:

Michel Lelonde

Technician

Signature:

Sylvie Sanchez
QC 5 Small FAB / QA

Submit

